

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015945**Date Inspected:** 01-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 9DW and Seg 9EW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW9C-007. The welder was identified as 053316 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-T.

OBG Seg 9CW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: CA061-006. The welder was identified as 067665 and was observed welding in the 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

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OBG Seg 9DW:

The SMAW process on weld joint no: CA065-002. The welder was identified as 067665 and was observed welding in the 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

OBG Seg 9CW and Seg 9DW:

The SMAW process on weld joint no's: SP134-001-044 to 054. The welder was identified as 066038 and was observed welding in the 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

Cross Beam 11 (CB11):

The SMAW process on weld joint no's: SP204-011-025, 027 and 029. The welder was identified as 069841 and was observed welding in the 4F position. ZPMC QC was identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-P-2114-FCM-1. See attached photo for further details.

The SMAW process on weld joint no's: DP201-011-009 to 016. The welder was identified as 067665 and was observed welding in the 4F position. ZPMC QC was identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-P-2114-FCM-1.

The SMAW process on weld joint no: CB202A-011-013. The welder was identified as 037723 and was observed welding in the 4G position. ZPMC QC was identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-T-2214-TC-U4b-FCM-1.

Cross Beam 12 (CB12):

This QA Inspector did random visual inspection of the welds of this CB. Weld areas identified as not complying with the Contract documents were identified and marked for the Contractor's QC to inspect / evaluate. Also, ZPMC QA identified as Mr. Zhong Wei is informed of the same.

Bay 7 - Cross Beam 18 (CB18):

The FCAW process on weld joint no's: DP3114-001-001, 002, 005 and 006. The welders were identified as 062447 and 217185 and were observed welding in the 2F position. ZPMC QC was identified as Guo Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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